

Date: Thursday, 30/10/2008 1:45:49 PM
 User: Julie Dawson

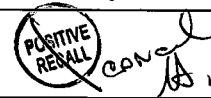
Process Sheet

Customer : CU-DAR001 Dart Helicopters Service	Drawing Name : VERTICAL TUNNEL AFT CENTER
Job Number : 43098	
Estimate Number : 13587	
P.O. Number :	Part Number : D38223
This Issue : 30/10/2008 S.O. No. :	Drawing Number : D38223 UNDER REVIEW 08/11/10
Prsht Rev. : NC	Project Number : IN0002
First Issue : // Type : R&D THERMOFORMING	Drawing Revision : A UNDER REVIEW
Previous Run : 42069	Material : MKYDEX6185S80P362015
Written By :	Due Date : 06/11/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est. A New Issue 08/09/17 DL	

PROTOTYPEPLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

30/10/2008 WH

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory
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Comment: Qty.: 5.4170 sf(s)/Unit Total: 10.8340 sf(s)
 Kydex velour matte, ivory

M-109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

08/11/03 WH

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/03 PH

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-3 and folio (FTA 9072 Prototype) using tool DT 9072

Dwg. Rev. A UNDER REVIEW
 Folio Rev. A

08/11/03 PH

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/03 PH

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 30/10/2008 1:45:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL AFT CENTER

Job Number: 43098

Part Number: D38223

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Handwritten: 08/11/16. X2

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Handwritten: 08/11/16. X2

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEER APPROVAL

Handwritten: 08.12.01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten: N/A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 08.12.01 Prototype

Job Completion



POSITIVE RECALL

EFFECTIVE 08.10.30

RELEASED

AUTH

DATE

Handwritten: Cancel

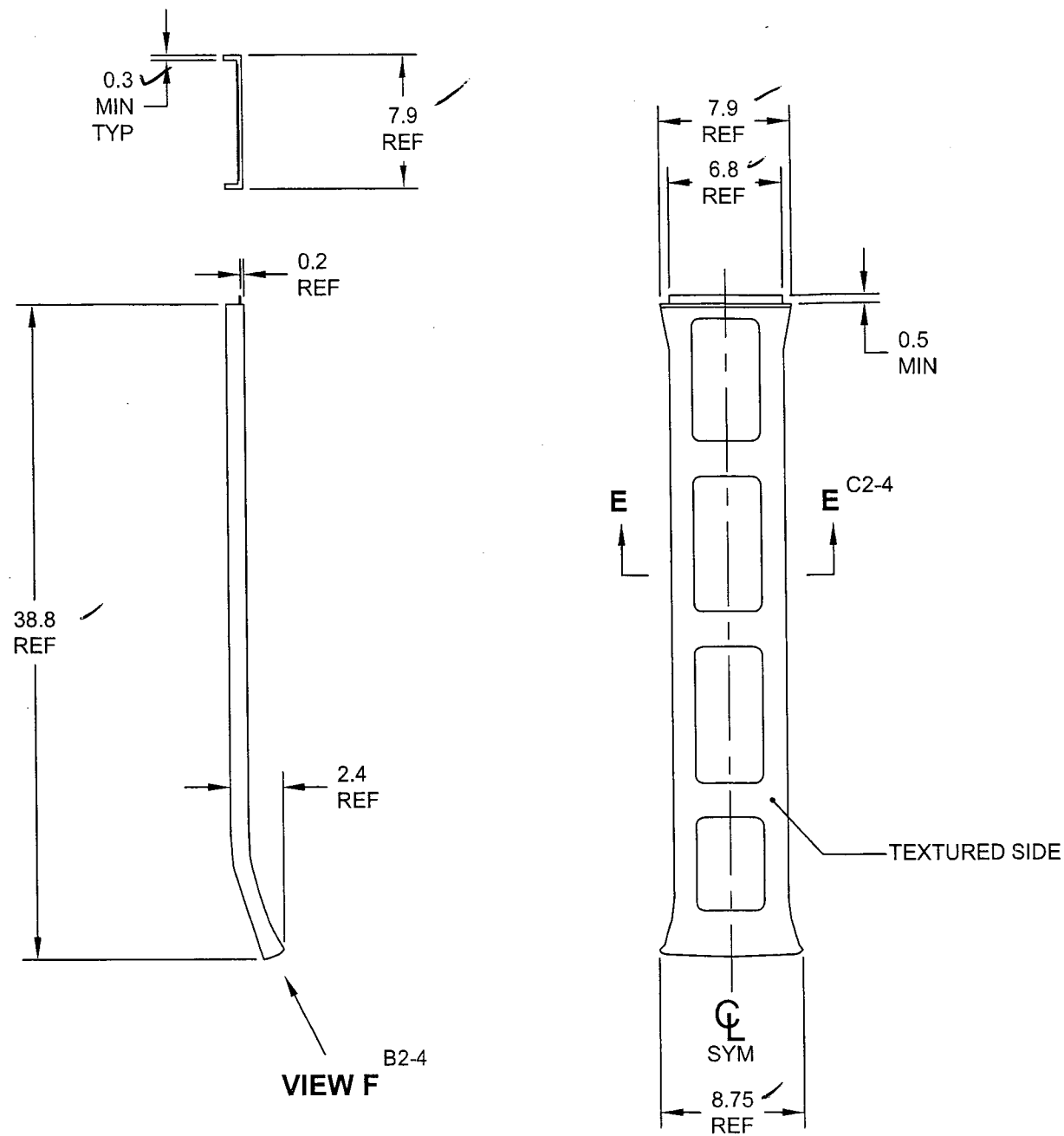
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

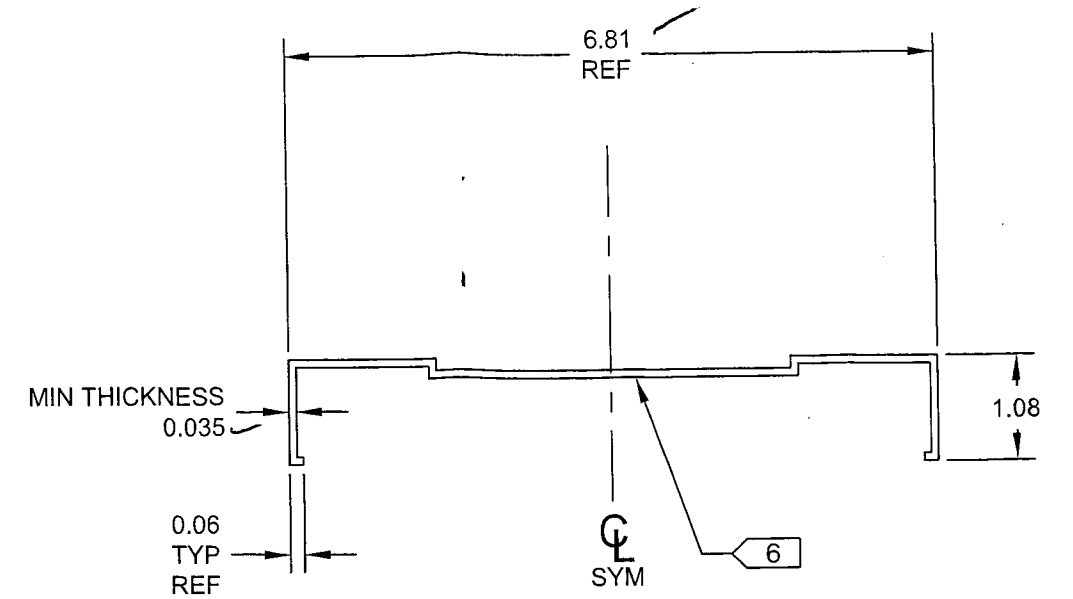
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

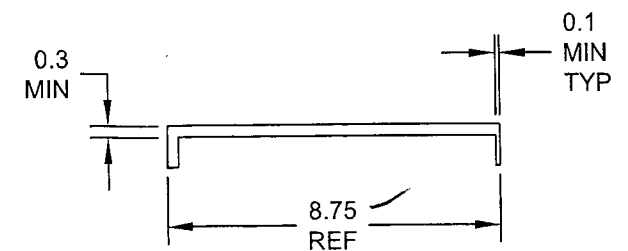
NOTE: Date & initial all entries



D3822-3 VERTICAL TUNNEL, AFT CENTER



SECTION E-E
SCALE 5X



VIEW F
SCALE 2X
(ROTATED 90° CW)

PROTOTYPE
08.11.10

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD

DESIGN	<i>Pgt</i>	DART AEROSPACE LTD	
DRAWN	<i>Pgt</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3822	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Receiving Report

Date: _____

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

~~No~~

N/A

Waybill Attached:

Yes

No

Shipment Complete

Yes

No

N/A

QC6 Inspection

77

1

N/A

Work Order

1

N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin:

Location

سابك
SABIC

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 8000/27

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43098
Description: Vertical Tunnel Aft Center / Prototype		Part Number: D3822-3
Inspection Dwg: D3822-3 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>BB</u>	Date: <u>08/11/27</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	min	0.310	✓			
7.9 (Ref)		7.91	✓			
0.2 (Ref)		0.2	✓			
38.8 (Ref)		38.8	✓			
2.4 (Ref)		2.5	✓			Ref dimension, but within tolerance
7.9 (Ref)		7.91	✓			
6.8 (Ref)		6.8	✓			
0.5	min	0.5	✓			
8.75 (Ref)		8.75	✓			
6.81 (Ref)		6.81	✓			
1.08	± 0.030	1.08	✓			
0.035	min	0.037	✓			

Measured by: <u>BB</u>	Date: <u>08/11/27</u>
Audited by: <u>[Signature]</u>	Date: <u>08-11-27</u>
Prototype Approval: <u>PA</u>	Date: <u>08-12-01</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	